

Date: Friday, 11/18/2005 3:04:14 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 24846		Part Number	: D265623	
Estimate Number	: 10615		Drawing Number	: D2656 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/18/2005 S.O. No. : N/A		Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/20/2005 Qty: 50 Um: Each	
Previous Run	: N/A				
Written By	<u>See COMMENT Below</u>				
Checked & Approved By	<u>See COMMENT Below</u>				
Comment:	: Est: D 02.10.25 Re-format KJ				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  
		Comment: PURCHASING Issue P/O: <u>146</u> Email or ship DXF file to vendor Laser Cut per Dwg D2656 flat pattern D2656-23 Material release note required
2.0	D265623F	Wearplate  
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Wearplate
3.0	PACKAGING 1	PACKAGING RESOURCE #1  
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material release note is attached
4.0	QC6	DIMENSIONAL CHECK  
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2656-23T1
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-11	4	Took 1 for template. Identify AS DT8837 <i>Permanent Change</i>	J	06-01-11	1	<i>BS</i> <i>06/01/11</i>	<i>J</i> 06-01-11

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 3:04:14 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARSHOE
Job Number: 24846		Part Number: D265623
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE		1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-23
7.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>SP 06/01/25</i>
8.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING		Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <i>a.m. 06-02-10</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>FC 06 02 10</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1		Identify and Stock Location: <i>FP</i>
11.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL		Inspection Level 21 <i>SAC 06/02/13 49</i>
Job Completion		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0000000000

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	:	0024846	Department Code:	
Project Name	:	D2656-23	Burden Flags	NNNNNNN
Project For	:	WK550	WO Status	Open
Work Order Type	:	Main	Invoice State	Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2656-23	Invoice Number	:
Description	:	Wearplate	Invoice Amount	0.00
Manufactured	:	Yes	Order Entry No	
Amount Req'd	:	50	OE Value	0.00
Amount Done	:	0	Est Margin	0.000%
Start Date	:	11-17-05	Actual Margin	0.000%
Est Finish Date	:	12-20-05	\$0 Posted to Finished Goods	
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

**INSPECTION CERTIFICATE**  
MATERIAL TEST/INSPECTION CERTIFICATES

源成實業股份有限公司  
YIEN MAU CORP.

INVOICE NO.:  
COMMODITY:

FORM #55  
PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304 NO.4 (SIC)  
FINISH, WITH 100 MICRUM ON MAIN SIDE, WITH BACK-PASS,  
SLITTED EDGE, AISI 304 VB FINISH, WITH PAPER INTERLEAVED,  
SLITTED EDGE.

SPECIFICATION:  
CUSTOMER:

AISI 304  
INTEGRIS METALS LTD

地址:高雄縣旗津鄉旗津路345號  
245, SHUAN AN RD., LU CHU HSIAO  
KAOSHING TAIWAN R.O.C.  
TEL: (07) 7622845 FAX: (07) 7673006  
CERTIFICATE NO: 9611162  
DATE OF ISSUE: 12/4/2004

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL-50 mm <sup>2</sup>					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm <sup>2</sup> )	T.S. (N/mm <sup>2</sup> )	E.L. (%)	HRB	H.V.	C x100	Si x100	Mn x100	P x1000	S x1000	N x100	O x100	
AISI 304-2B (725-4229)	1	1,465	3,230	YU231320	3AS44463B-21	268	685	56	81	156	4.6	51	119	24	2	804	1821	2.7
24GA48"X120"	1	1,464	3,228	YU231320	3AS44463B-22	268	685	56	81	156	4.6	51	119	24	2	804	1821	2.7
24GA48"X120"	1	1,464	3,228	YU230510	3BS37609B-61	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
(725-5860)	1	1,375	3,031	YU230510	3BS37609B-52	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
20GA48"X120"	1	1,445	3,186	YU134975	3AS43434A-1	312	666	61	82	161	4.1	49	112	24	2	809	1821	2.8
(725-5860)	1	1,497	3,300	YU231066	3AS42732-4	301	684	49	84	166	3.7	40	116	27	5	810	1824	3.7
18GA48"X120"	1	1,453	3,203	YU231066	3AS42732-5	301	684	49	84	166	3.7	40	116	27	5	810	1824	3.7
18GA48"X120"	1	1,455	3,208	YU231066	3AS42732-6	301	684	49	84	166	3.7	40	116	27	5	810	1824	3.7
(725-5166)	1	1,423	3,137	YU231143	3AS42886A-6	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA48"X120"	1	1,424	3,139	YU231143	3AS42886A-7	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA48"X120"	1	1,420	3,131	YU231143	3AS42886B-1	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
(725-7049)	1	1,441	3,177	YU231075	3AS42917A-1	302	650	52	83	162	4.2	48	119	28	6	806	1813	3.4
18GA48"X120"	1	1,441	3,177	YU231075	3AS42917A-2	302	650	52	83	162	4.2	48	119	28	6	806	1813	3.4
(725-8059)	1	1,420	3,131	YU231075	3AS42917A-3	302	650	52	83	162	4.2	48	119	28	6	806	1813	3.4
14GA48"X120"	1	1,420	3,131	YU231075	3AS42917A-4	302	650	52	83	162	4.2	48	119	28	6	806	1813	3.4
14GA48"X120"	1	1,446	3,188	YU133202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
(725-8277)	1	1,405	3,097	YU133202	3AS45623A-213	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
14GA48"X120"	1	1,540	3,305	YU133202	3AS45623A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
	18	25,998	57,377															

Remark:  
NO MERCURY CONTAMINATION  
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS  
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Bread required for all Heat NO.  
PRODUCT IN ACCORDANCE WITH ASTM A240, A480,  
A262B, ASME SA240, QQS766D.

YIEN MAU CORP.

*[Signature]*  
Manager of Quality Assurance

20g<sup>a</sup>

304

2455

(0.037)

PO # 267 146



New Zealand Steel Limited  
Glenbrook, South Auckland  
Postal: Private Bag 82121, Auckland, New Zealand  
Telephones: (09) 375 8999 / 375 8111 Auckland  
(09) 235 8088 / 235 3533 Waiuku  
Fax: (09) 375 8950

## TEST CERTIFICATE

Ref: 537923650

Reissued 22/8/2005

CUSTOMER	Wilkinson	P5C5C5-RICO2	SPECIFICATION	ASTM A108 CS Type A	CERTIFICATE No	TC116858
CUSTOMER QIN	98-21N-742		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL QIN	486968		DIMENSIONS	0.033" x 48" x Coil	DATE	19 August 2005

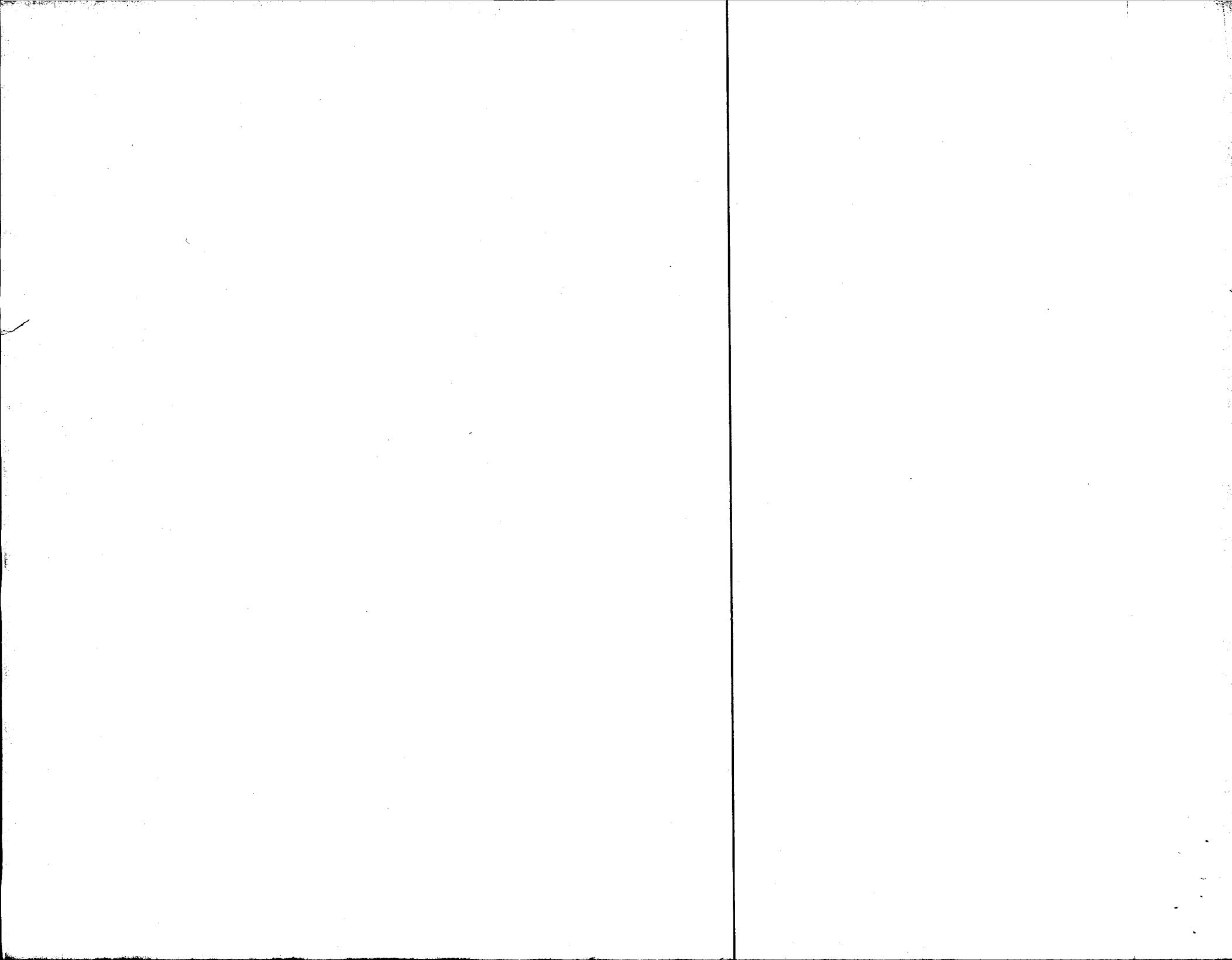
PACK NUMBER	HEAT NO	CHEMICAL COMPOSITION PERCENT													MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE( )	BEND	YIELD	T.S.	%ELONG G.L=	HARDNESS HRB	r	LENGTH (feet)
		x100		x1000											x10000	x100	180°							
R9-466088-06	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700
R9-466081-06	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700
R9-466082-06	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651
R9-466083-06	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=0 (B)=90	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 6mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+Si/24 (D)=
--	--	---	--	---	---	--------------------------

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Antish Misra*  
OC METALLURGIST

*Qoga ns* *PO# 267, 1466*





New Zealand Steel Limited  
Glenbrook, South Auckland  
Postal: Private Bag 92121, Auckland, New Zealand  
Telephones: (09) 375 8998 / 375 8111 Auckland  
(09) 235 8068 / 235 3535 Waiuku  
Fax: (09) 375 8959

## TEST CERTIFICATE

Ref. 5210/22485

CUSTOMER	Wilkinson	SPECIFICATION ASTMA1808 CS Type A													CERTIFICATE No TC112397								
CUSTOMER D/N	90-21N-686	PRODUCT CRA WIDE COIL													PAGE	1 of 1							
MILL Q/N	480737	DIMENSIONS 0.055" x 48" x Coil													DATE	09 June 2005							
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT													MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	ND	Ti	Al	B	N2	CE( )	BEND 180°	YIELD	T.S.	%ELONG G.L.*	HARDNESS HRB	r ( )
		x100			x1000									x10000	x100								
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1				Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1				Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				Good				50		1335
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1				Good				50		1581
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1				Good				48		1785

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r90 (C)=r45 (D)=(r0+r90+2r45)/4	IMPACT TEST (A)=5mm x 5mm (B)=10mm x 10mm (C)=10mm x 10mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Ni+Cu)/15 (C)=C+Mn/6+Si/24 (D)=
--	--	---	--	---

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

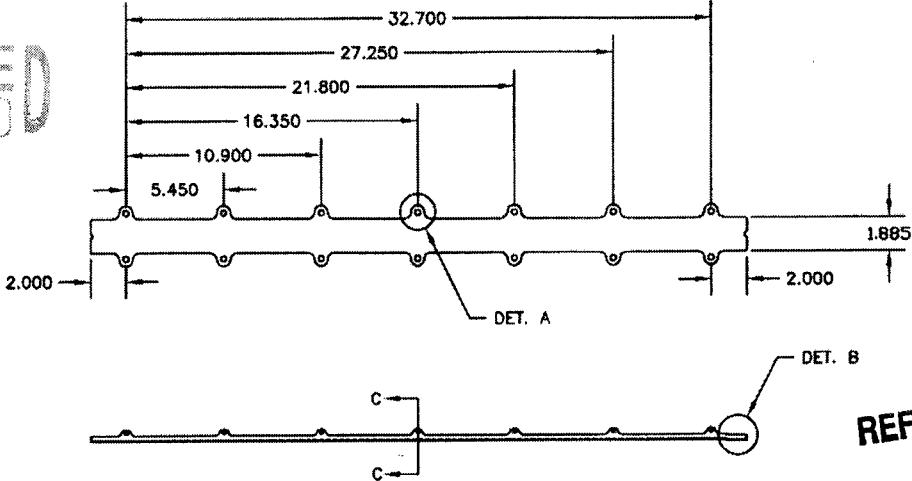
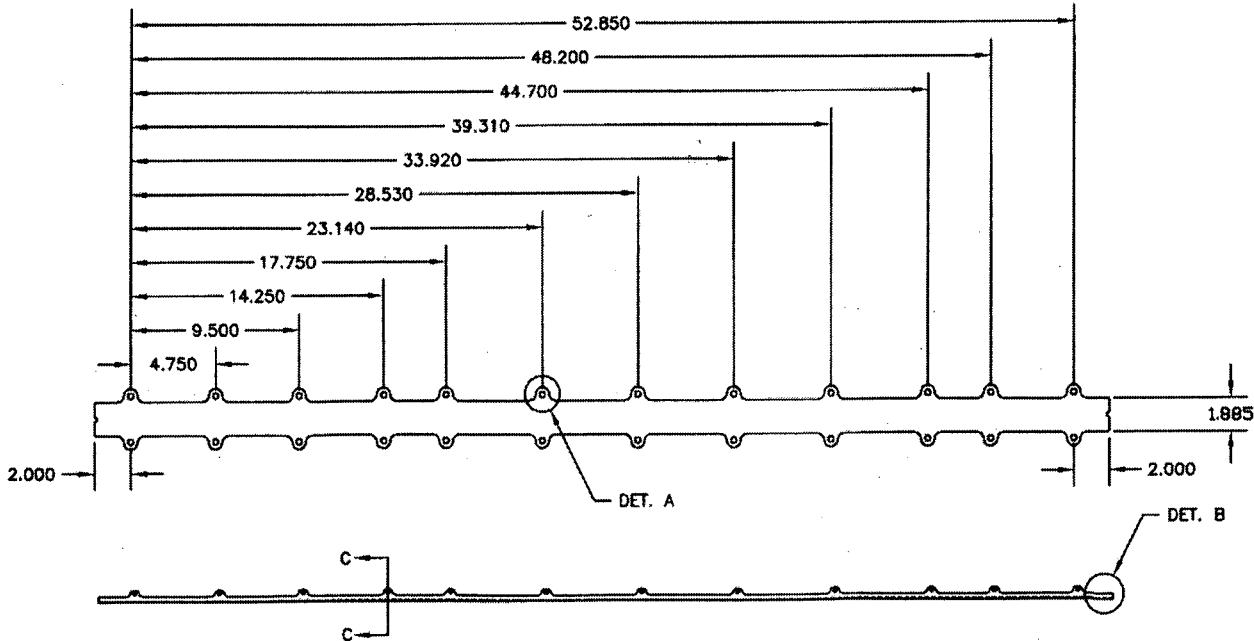
APPROVED *Amish Misra*  
QC METALLURGIST

16 ga ms

PO# 146, 267, 245,

**DART**

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656
DATE 05.08.17		REV. D SHEET 2 OF 4 TITLE WEARSHOE SCALE 1:10

**D2656-21****RELEASED**  
05.09.06 *[Signature]***D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W

SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

TOLERANCES ARE PER DART QSI 018

UNLESS OTHERWISE NOTED

**Copyright © 1997 by DART AEROSPACE USA, INC.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.